CONFIDENTIAL

1-1-54
31-12-55
8
AS-1 MOTOR DWGS
PROJ 2045

25X1

AS-1 Motor Drawings

1954 - 1955

25X1

CONFIDENTIAL

CONTRACT NO. XG-1384

M O T O R - 51601

MAINTENANCE & OPERATION MANUAL

1. BRUSH ADJUSTMENT & REPLACEMENT

Brushes used are of lifetime material and need not be replaced. Adjustment is initially made at assembly and due to lifetime qualities no adjustment should be necessary. If, for any reason due to breakage, etc., brushes are to be replaced, they should be set to 45 grams pressure at the commutator dia. (.281 dia.). Adjustment is made by turning set screw behind brush.
This replacement and adjustment can be made only on disassembling.

2. GOVERNOR ADJUSTMENT

To adjust governor, remove 6-32 set screw in outer case, rotate motor shaft until slotted screw appears in wire groove in housing.
Turn slotted screw, very carefully, in or back out to adjust governor.
(If this adjustment is not sufficient, remove outer cover and bend leaf carefully in direction desired for adjustment.)

3. BEARING LUBRICATION

Bearings are of double shielded type, packed with grease at factory and need no lubrication.

4. DISASSEMBLING MOTOR FOR MAINTENANCE OR PARTS REPLACEMENT

a. Loosen set screw in cover, slip cover from housing.
b. Loosen 1-64 round head machine screw in mounting face of gear box end. Remove terminal block from gear box. Unsolder leads from terminal.
c. Loosen three 2-56 filister head machine screws in mounting face of gear box end. Remove gear box carefully from housing. Note that pinion will come off armature shaft upon removal of gear box. Innermost bearing in gear box should come off armature shaft and remain in gear box.
d. Remove three 1-64 flat head machine screws on perifery of housing at motor shaft end. Remove end cap at motor shaft end.
e. Armature shaft may now be removed from housing.
f. Unsolder leads from resistor at end cap.
g. Loosen two 3-48 set screws in housing and remove magnets.
h. Loosen two 1-64 flat head machine screws in housing end and slide brush holder out end of housing.
i. Loosen two 1-64 flat head machine screws in brush holder on end cap and remove brush holder from end cap.

MOTOR IS NOW DISASSEMBLED

5. DISASSEMBLING GEAR BOX

Disassemble two halves of gear box by inserting 3-48 screw in mounting hole in solid section. Turn screw down until two halves have parted or become loose enough to part by hand.
Pinion shaft with nylon gear will remain in inner half and gear shaft extension will remain in outer half.
Gear shaft may be pushed out by hand from outer half.
To remove pinion shaft from inner half, push shaft from bearing. This will force off nylon gear at the same time.

GEAR BOX IS NOW DISASSEMBLED

STAT

CONTRACT NO. XG-1384

M O T O R - 51601

MAINTENANCE & OPERATION MANUAL

1. BRUSH ADJUSTMENT & REPLACEMENT

Brushes used are of lifetime material and need not be replaced. Adjustment is initially made at assembly and due to lifetime qualities no adjustment should be necessary. If, for any reason due to breakage, etc., brushes are to be replaced, they should be set to 45 grams pressure at the commutator dia. (.281 dia.). Adjustment is made by turning set screw behind brush.
This replacement and adjustment can be made only on disassembling.

2. GOVERNOR ADJUSTMENT

To adjust governor, remove 6-32 set screw in outer case, rotate motor shaft until slotted screw appears in wire groove in housing. Turn slotted screw, very carefully, in or back out to adjust governor. (If this adjustment is not sufficient, remove outer cover and bend leaf carefully in direction desired for adjustment.)

3. BEARING LUBRICATION

Bearings are of double shielded type, packed with grease at factory and need no lubrication.

4. DISASSEMBLING MOTOR FOR MAINTENANCE OR PARTS REPLACEMENT

a. Loosen set screw in cover, slip cover from housing.
b. Loosen 1-64 round head machine screw in mounting face of gear box end. Remove terminal block from gear box. Unsolder leads from terminal.
c. Loosen three 2-56 filister head machine screws in mounting face of gear box end. Remove gear box carefully from housing. Note that pinion will come off armature shaft upon removal of gear box. Innermost bearing in gear box should come off armature shaft and remain in gear box.
d. Remove three 1-64 flat head machine screws on perifery of housing at motor shaft end. Remove end cap at motor shaft end.
e. Armature shaft may now be removed from housing.
f. Unsolder leads from resistor at end cap.
g. Loosen two 8-48 set screws in housing and remove magnets.
h. Loosen two 1-64 flat head machine screws in housing end and slide brush holder out end of housing.
i. Loosen two 1-64 flat head machine screws in brush holder on end cap and remove brush holder from end cap.

MOTOR IS NOW DISASSEMBLED

STAT

CONTRACT NO. XG-1384

M O T O R - 51601

MAINTENANCE & OPERATION MANUAL (Cont'd)

5. DISASSEMBLING GEAR BOX

Disassemble two halves of gear box by inserting 8-48 screw in mounting hole in solid section. Turn screw down until two halves have parted or become loose enough to part by hand.
Pinion shaft with nylon gear will remain in inner half and gear shaft extension will remain in outer half.
Gear shaft may be pushed out by hand from outer half.
To remove pinion shaft from inner half, push shaft from bearing. This will force off nylon gear at the same time.

GEAR BOX IS NOW DISASSEMBLED

STAT

MAINTENANCE INSTRUCTIONS

This unit has been designed so that it does not require preventive maintenance. The bearings are sealed with lifetime lubricant; the brushes and commutator should not require replacement for the motor's normal life.

It may be necessary to occasionally reset the governor speed. You should proceed with this adjustment in the following order, using the following equipment or its equivalent:

EQUIPMENT NECESSARY TO MAKE ADJUSTMENTS:

1. An Oscilloscope
2. a 6-Volt Battery Power Supply
3. An Ampmeter in the range of 0 to 3 Amp,
4. An accurate Calibrated Strobotac or a tachometer and timer.
5. A Prony Brake or other means of loading the motor under operating conditions, as called for under Spec. # (Motor end = 4-ounce inch).

PROCEDURE:

1. Connect motor with amp meter in series with one lead connected so that it will read on scale.
2. The oscilloscope should be connected with the vertical amplifier across the two motor leads.
3. Set the sweep frequency on the oscilloscope to approximately 35 cycles.
4. Turn the gain of the average oscilloscope to the maximum position.
5. The oscilloscope, when the motor is running with no load, should show no pronounced spikes on the screen.
6. Each commutator bar will give you an indication of 1/9 of the screen length so that you should get 9 inflections showing the commutator of each bar. Any pronounced spikes of greater amplitude than the average inflections will show that you have either a high or a low bar on the commutator. This inflection will not normally affect the power or the running of the motor but will create radio frequency noise. If the motor has these spikes, it should be replaced.
7. If the motor appears uniform with no spikes in the oscilloscope, you can proceed to adjust the governor to the proper speed (2100 rpm on the high speed and 368.4 rpm on the low speed end.)
8. Remove large set screw, which gives you access to the governor adjusting screw.
9. A small screw driver, having a properly ground blade to fit a standard 2-64 round head screw, is used to slowly turn the rotating shaft until this governor screw is accessible through the hole. (This screw will be the natural stainless steel color. Any other screws which might show up as you are rotating the governor will be covered with a gray paint and should not be distrubed.
10. To speed the motor up the screw should be turned in a clockwise direction. Conversely: to slow down the motor, turn in a counter-clockwise direction.
11. Extreme care should be used in making this adjustment as excessive pressure downward on this screw will permanently displace the governor reed. (It is well to get acquainted with this governor arrangement by referring to the drawings showing this particular part).

12. Check the speed by the use of the strobotac or counter and timer combination. (It is well to let the motor run a few minutes before timing so that the motor and governor will stabilize. The motor should be run a few minutes before checking after any adjustment).

13. The Prony Brake should be connected to the motor shaft so that a normal load is applied when you are checking the speed.

14. Care should be exercised when removing or installing the pin through the motor shaft, as excessive impact on this shaft may permanently harm the bearings.

9. Slowly turn the motor shaft until the governor screw is adjacent straight hole (this screw will be the natural stainless steel color) other screw that shows up

51601 PARTS LIST

PART NO.	TITLE	QUAN/UNIT
51601-01	PINION	1
-02	GEAR	1
-03	PINION	1
-04	GEAR	1
-05	ARMATURE HOUSING	1
-06	GEAR BOX	1
-07	END CAP	1
-08	TUBE	1
-09	TUBE INGRAVING	1
-010	ARAMTURE SHAFT	1
-011	BRUSH HOLDERS	2
-012	LAMINATION	40 pl.2 Fishpaper-.020"Thick
-013	GOVERNOR ASSEMBLY	1
-014	BODY COVER	1
-015	LEAF CONTACT LONG	1
-016	CONTACT	1
-017	BLOCK WEIGHT	1
-018	TERMINAL BLOCK	1
-019	PIN TERMINAL	2
-020	FIELD MAGNET	2
-021	CLAMP COMMUTATOR	2
-022	CLAMP COMMUTATOR	1
-023	INSULATORS	4 of Each Kind
-024	BRUSH	4
-025	SPRING	4
-026	TENSION WASHER	1
-027	SILVER BAR	9
-028	SLIP RING	2
-029	FISH PAPER BETWEEN SLOTS IN LAMINATION	9

STAT

51601 HARDWARE PARTS LIST

PART NO.	QUANTITY	DESCRIPTION	SIZE	MATERIAL
	5 Ea.	R.H.Machine Screws	1-64x3/16 Lg.	S.S.
	1 Ea.	R.H.Machine Screws	2-64x3/64 Lg.	S.S.
	2 Ea.	Contacts	Mallory #253-804	Silver
	2 Ea.	Dowel Pins	3/32 dia. x5/8 Lg.	S.S.
	5 Ea.	Fil.Hd. Machine Screw	2-56x 13/16 Lg.	S.S.
	4 Ea.	Ball Bearings	N.H.Ball Brg.#SFR156PP	S.S.
	2 Ea.	Ball Bearings	N.H.Ball Brg.#SFR1PP	S.S.
	7 Ea.	F.H.Machine Screws	1-64x1/4 Lg.	S.S.
	4 Ea.	R.H.Machine Screws	1-64x1/8 Lg.	Brass
	4 Ea.	Soc.Set Screws	6-32x5/64 Lg.	S.S.
	3 Ea.	Soc.Set Screws	3-48x3/64 Lg.	S.S.
	1 Ea.	Resistor Ohmite	1/2 Watt 82 ohm	
	2 Ea.	Tinned Buss Wires	015 dia.x5/16 Lg.	Copper
	2 Ea.	Lead Wires	#24x2½ Lg.	

ARMATURE WINDING: 9 Coils, 45 Turns, #43 Wire, Double Formex

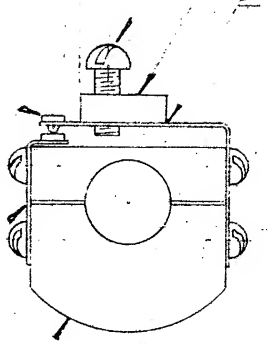
(1) #2-64 RD. HD. SCREW 3/16 LG.

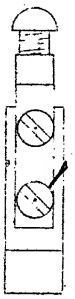
BLOCK #51601-017

.070

LEAF #51601-015

MALLORY CONTACT SILVER



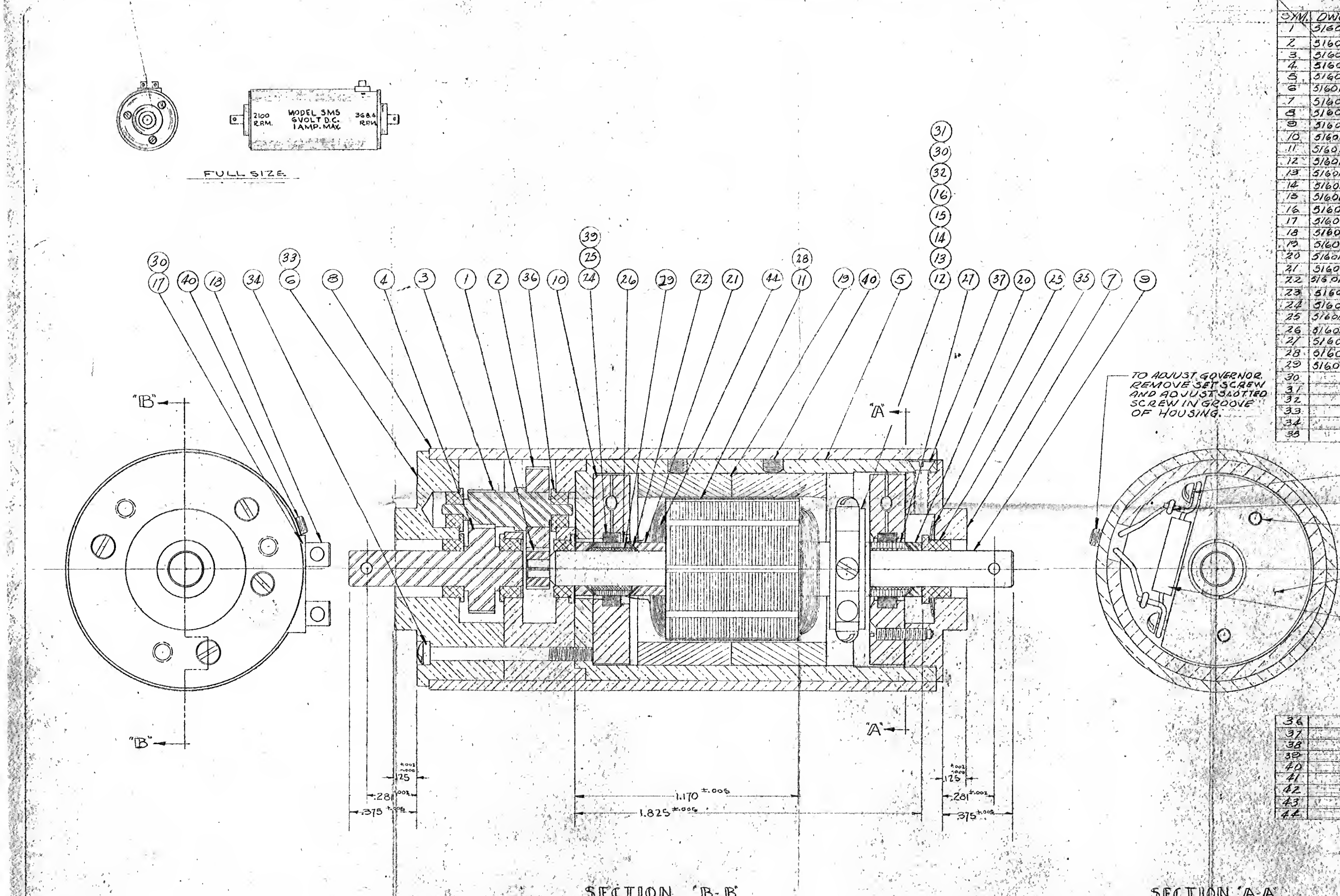


(4) #1-64 RD. HD. SCREW 3/16 LG

CONTACT #51601-016

BODY #51601-014

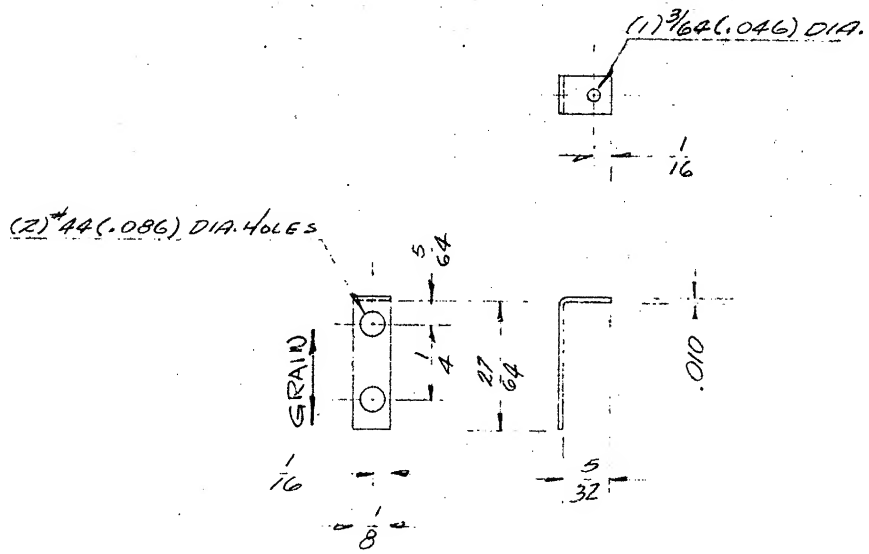
TOLERANCE: UNLESS OTHERWISE NOTED DECIMAL ±.005 FRACTION ±1/64			
BY DJS DATE 6-6-65			STAT
	SCALE 2:1		
		TITLE ASSY., GOVERNOR	
REVISION BY DATE CHANGE	MAT'L NOTED		DWG NO 51601-013



PARTS LIST

SYM.	DWG. No.	Q/U.	NAME	
1	51601-01	1	PINION	
2	51601-02	1	GEAR	
3	51601-03	1	PINION	
4	51601-04	1	GEAR	
5	51601-05	1	ARMATURE HOUSING	
6	51601-06	1	GEAR BOX	
7	51601-07	1	END CAP	
8	51601-08	1	TUBE	
9	51601-010	1	ARMATURE SHAFT	
10	51601-011	2	BRUSH HOLDER	
11	51601-012	42	LAMINATION	
12	51601-013	1	GOVERNOR	
13	51601-014	1	BODY	
14	51601-015	1	LEAF CONTACT LG.	
15	51601-016	1	CONTACT	
16	51601-017	1	BLOCK, WEIGHT	
17	51601-018	1	TERMINAL BLOCK	
18	51601-019	2	PIN, TERMINAL	
19	51601-020	2	FIELD MAGNET	
20	51601-021	2	CLAMP COMMUTATOR	
21	51601-022	1	CLAMP COMMUTATOR	
22	51601-023	4	INSULATORS	
23	51601-024	4	BRUSH	
24	51601-025	4	SPRING	
25	51601-026	1	TENSION WASHER	
26	51601-027	9	SILVER BAR	
27	51601-028	2	SLIP RING	
28	51601-029	9	FISH PAPER	IN LAMINATIONS
29	51601-030	2	TUBE INSULATION	
30		3	R.H. MACH. SW. S.S.	1-64 x 3/16 LG
31		1	R.H. MACH. SW. S.S.	2-64 x 3/64 LG
32		2	CONTACTS #233-804	MALLORY
33		2	DOWEL PIN S.S.	3/32 D. x 5/8 LG.
34		3	FIL. H. MACH. SW. S.S.	2-56 x 13/16 LG.
35		4	BALL BEARING S.S.	N.H. #SFR1SPP
36		2	BALL BEARINGS SS	N.H. #SFR1PP
37		7	R.H. MACH. SW. SS	#1-64 x 1/4 LG
38		4	R.H. MACH. SW. BRASS	#1-64 x 1/8 LG.
39		4	SOC. SET SW. S.S.	6-32 x 3/16 LG.
40		3	SOC. SET SW. S.S.	3-48 x 3/16 LG
41		1	RESISTOR 1/2W 82 Ω	
42		2	WIRE, TINNED BUSS	.015 DIA. x 5/16 LG
43		2	WIRE, LEAD	#24 x 2 1/2 LG.
44		9 COILS	#43 WIRE DOUBLE FORMEX	45 TURNS.

BY D.L. DATE 7-28-55
SCALE 4/1
TITLE ASSY. MOTOR
DWG. NO. 51601-200



STAT

REVISION	BY	DATE	CHANGE

TOLERANCES: UNLESS OTHERWISE NOTED:
DECIMAL ± .005 FRACTION ± 1/64

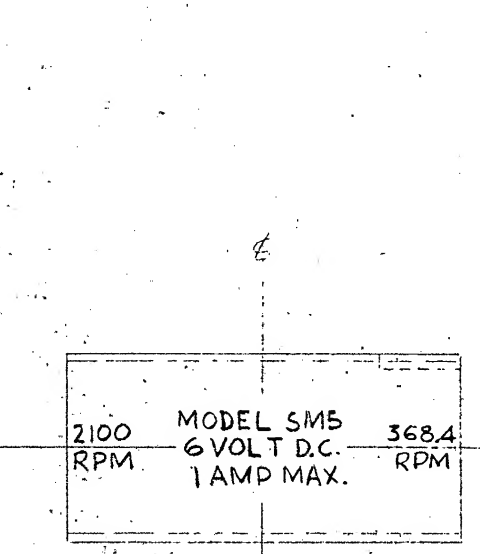
BY DJG DATE 6-7-55

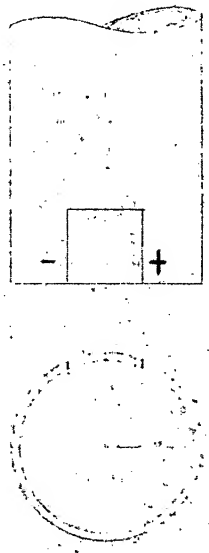
SCALE 2/1

TITLE CONTACT

MAT .010 BERYLLIUM COPPER

DWG 51601-016





ALL LETTERING TO BE 7/64 HIGH, GOTHIC BOLD. 1/16 SPACE BETWEEN LINES.
LETTERING TO BE FILLED WITH WHITE PAINT.
LETTERING CENTERED AS SHOWN.

TOLERANCE FRAC. ± 1/64

BY DTB DATE 7-20-55 | CHECKED DATE | SCALE 1/1

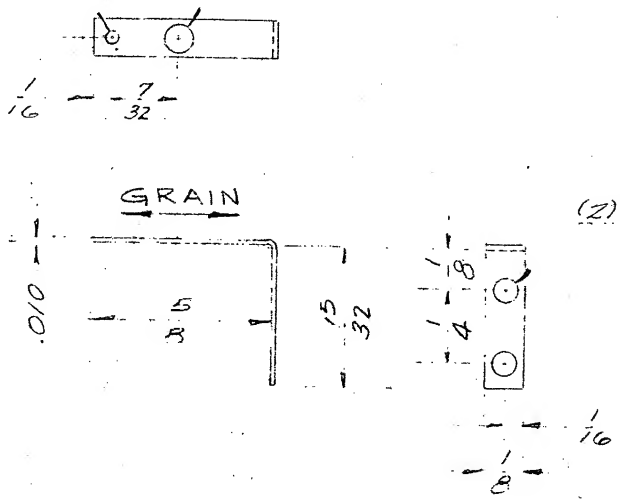
STAT

TITLE ENGRAVING, TUBE

MAT. ALUM. TUBE DWG # | DWG NO. 51601-09

(1) 31/64 (.046) DIA.

(1) 3/32 DIA. HOLE



(2) #44 (.086) DIA. HOLES

NOTE:
SMOOTH ALL OVER.

STAT

TOLERANCE UNLESS OTHERWISE NOTED
DECIMAL ±.005 FRACTION ±1/64

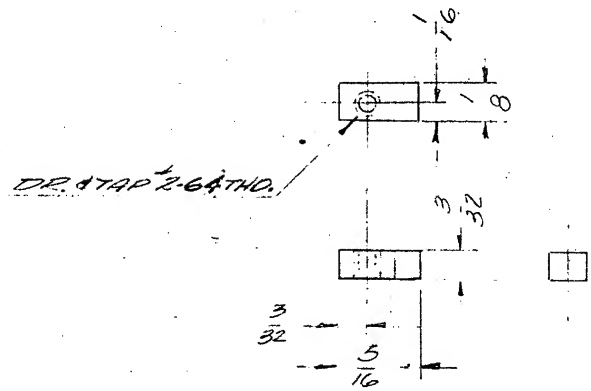
BY 1915 DATE 6-7-53

TITLE LEAF CONTACT, LONG

REVISION	BY	DATE	CHANGE

MAT. .010 BERYLLIUM COPPER

DWG NO. 51601-015



TOLERANCES: UNLESS OTHERWISE NOTED
DECIMAL ±.005 FRACTION ±1/64

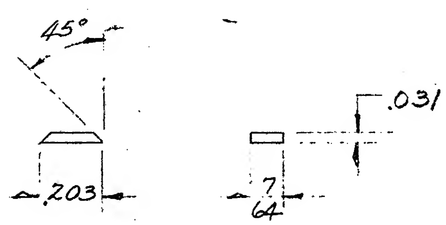
BY D/B DATE 6-7-55

SCALE 2:1

TITLE BLOCK

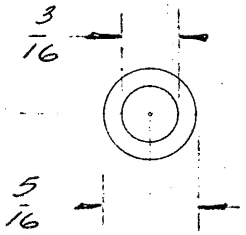
MAT. BRASS

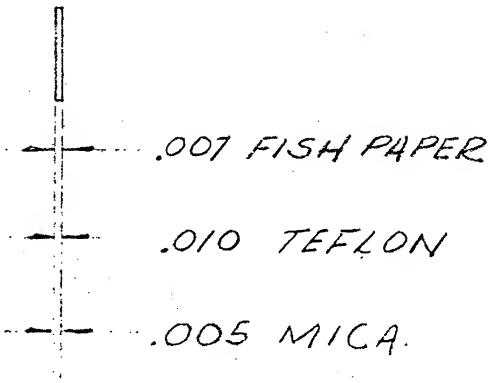
DWG NO 51601-017



STAT

TOLERANCE DEC. ±.005 FRAC. ±1/64	
BY [illegible] DATE 7-21-55	SCALE 2:1
TITLE	BAR, SILVER
MAT. COINED SILVER	DWG NO 51601-027





(4.) INSULATORS OF EACH MAT. REQ'D. PER. UNIT.

TOLERANCE FRAC ± 1/64

BY DTH DATE 7.21.51

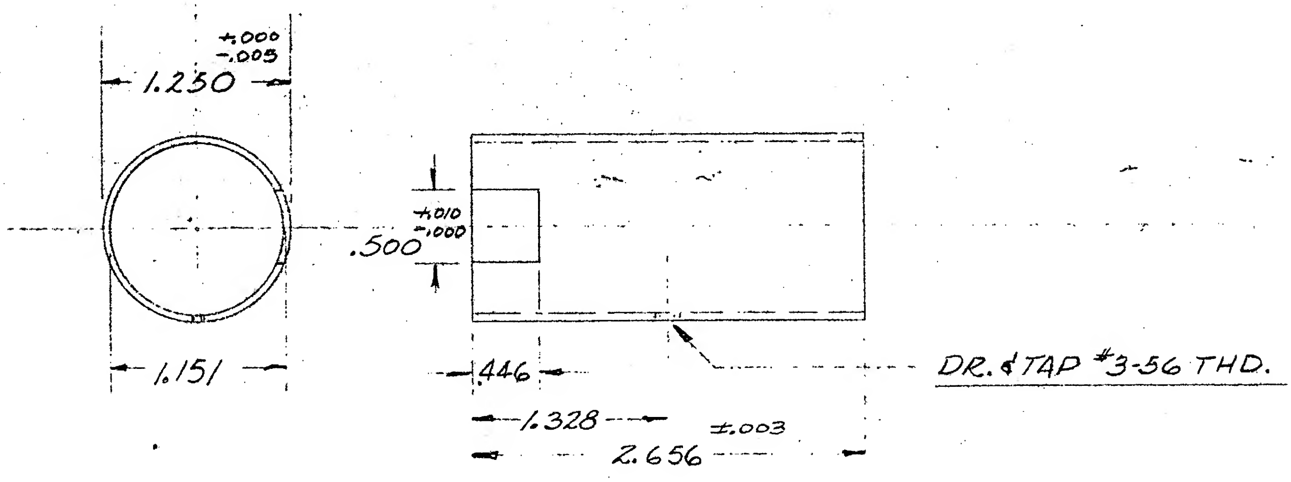
SCALE 2:1

STAT

TITLE INSULATORS

MAT. NOTED

DWG NO 51601-023



ENDS MUST BE PERPENDICULAR TO SURFACE OF TUBE.

TOLERANCE UNLESS NOTED
DEC. ±.005 FRAC. ± 1/64 ANG. ± 1/2°

BY WJB DATE 7-26-55 | CHECKED DATE

SCALE 1:1

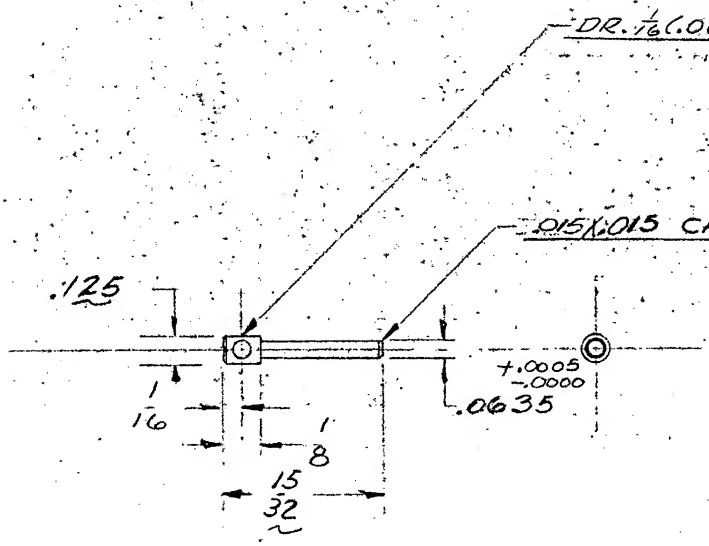
STAT

TITLE TUBE

FIN. BLACK ANODIZE

MAT. 24 ST ALUM.

DWG. NO. 51601-08



TOLERANCE UNLESS NOTED OTHERWISE:
DEC. ±.005 FRAC. ± 1/64 ANGULAR ± 1/2°

DWN. BY	DATE	CHECKED	DATE
[illegible]	7-5-55		

SCALE 2:1

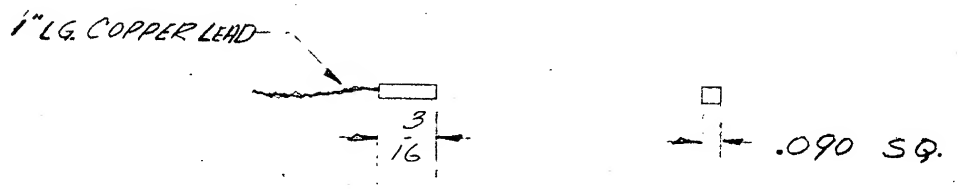
STAT

REV.	BY	DATE	CHANGE
B	JE [illegible]	7-15-55	15/32 WAS 35/64
A	JE [illegible]	6-8-55	.125 WAS .093

TITLE: PIN, TERMINAL

MAT. BRASS, FREE TURNING

DWG NO 51601-019 B



#SN10 MORGANITE
85% SILVER
15% GRAPHITE

TOLERANCE
DEC. ±.005 FRAC. ±1/64

BY JJ DATE 7-21-55

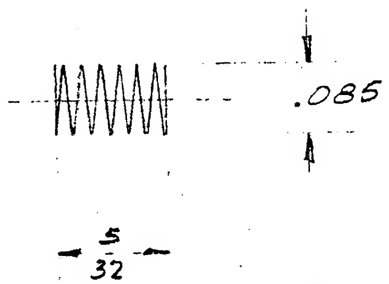
SCALE 2:1

STAT

TITLE BRUSH

MAT. NOTED

DWG NO 51601-024

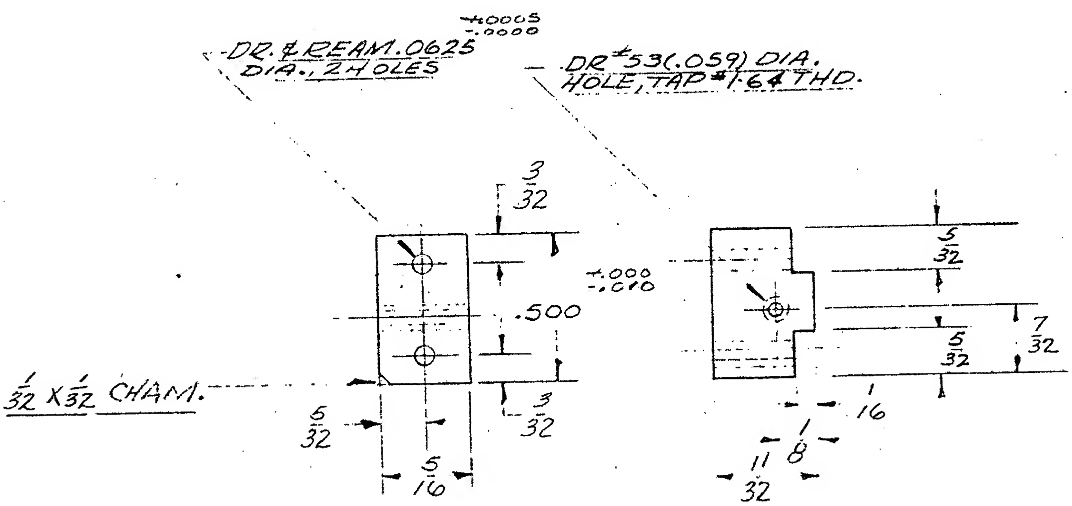


6 TURNS .008 DIA. COPPER WIRE.

TOLERANCE
DEC. ± .005 FRAC. ± 1/64

STAT

DN [illegible]	DATE 7-21-55	
	SCALE NONE	
		TITLE SPRING
MAT NOTED		DWG NO 5601-025



TOLERANCE UNLESS NOTED OTHERWISE
DEC. ± .005, FRAC. ± 1/64 ANGULAR ±

STAT

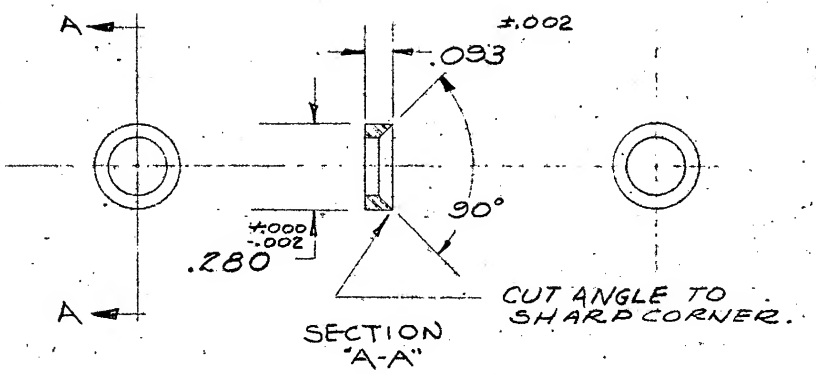
REV.	BY	DATE	CHANGE
B	DTB	7-11-55	MAT: WAS NYLON
A	J.E. DTB	7-8-55	1/32 WAS 1/16

DWN. BY: DTB DATE: 7-5-55
CHECKED DATE
SCALE 2:1

MAT. BAKELITE

TITLE BLOCK, TERMINAL

DWG NO. 51601-018



TOLERANCE UNLESS NOTED:
DEC. ±.005, FRAC. ±1/64, ANGULAR ± 1/2°

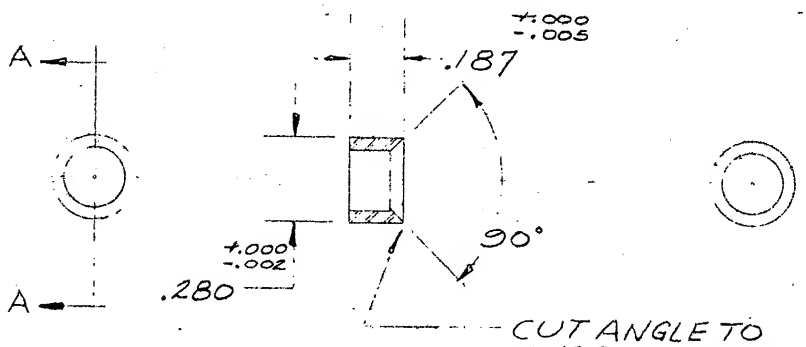
BY W.T.H.	DATE 7-20-55	CHECKED	DATE
		SCALE 2:1	

STAT

TITLE CLAMP, COMMUTATOR

MAT. 303 STAINLESS STL.

DWG NO. 5/601-021



SECTION
A-A

TOLERANCE UNLESS NOTED
DEC. ±.005, FRAC. ±1/64 ANGULAR ±½°

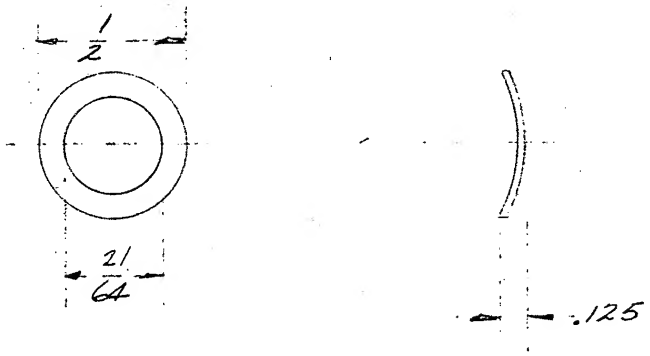
BY DTB	DATE 7-20-55	CHECKED · DATE	
		SCALE 2:1	

TITLE CLAMP, COMMUTATOR

MAT. 303 STAINLESS STL.

DWG NO. 51601-022

STAT



TOLERANCE DEC. ± .005 FRAC. ± 1/64

BY DTB DATE 7-21-55

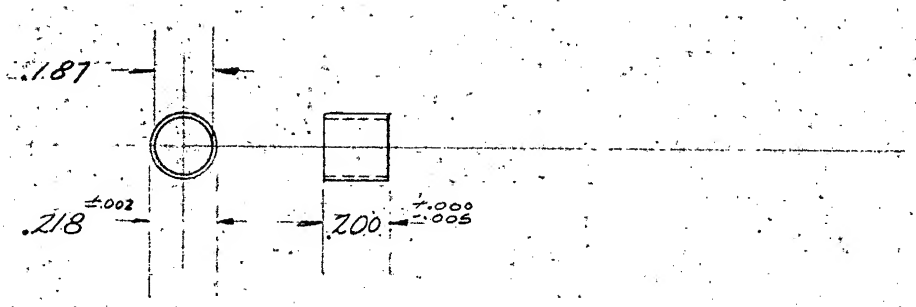
SCALE 2:1

STAT

TITLE TENSION WASHER.

MAT. .008 THK. BERYLLIUM COPPER

DWG NO 51601-026



TOLERANCE
DEC ±.005 FRAC ±1/64

BY DHG DATE 7-21-55

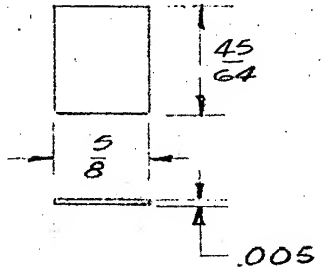
SCALE 2:1

STAT

TITLE TUBE, INSULATING

MAT NYLON G.S.

DWG NO. 51601-028



STAT

TOLERANCE DEC. ± .006 FRAC. ± 1/64

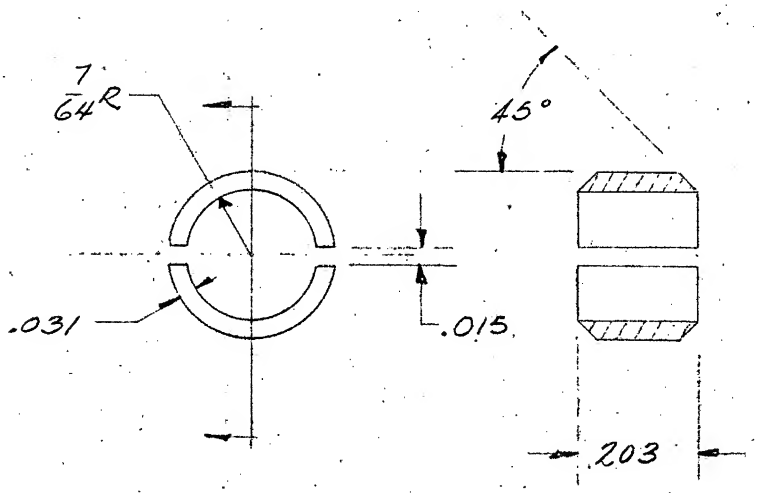
BY DTG DATE 7-21-55

SCALE 1:1

TITLE INSULATION, ARMATURE

MAT. FISH PAPER

DWG. NO 51601-029



TOLERANCE DEC ±.005 FRAC, ±1/64 ANG. ± 1/2°

BY OTB DATE 7-U-55

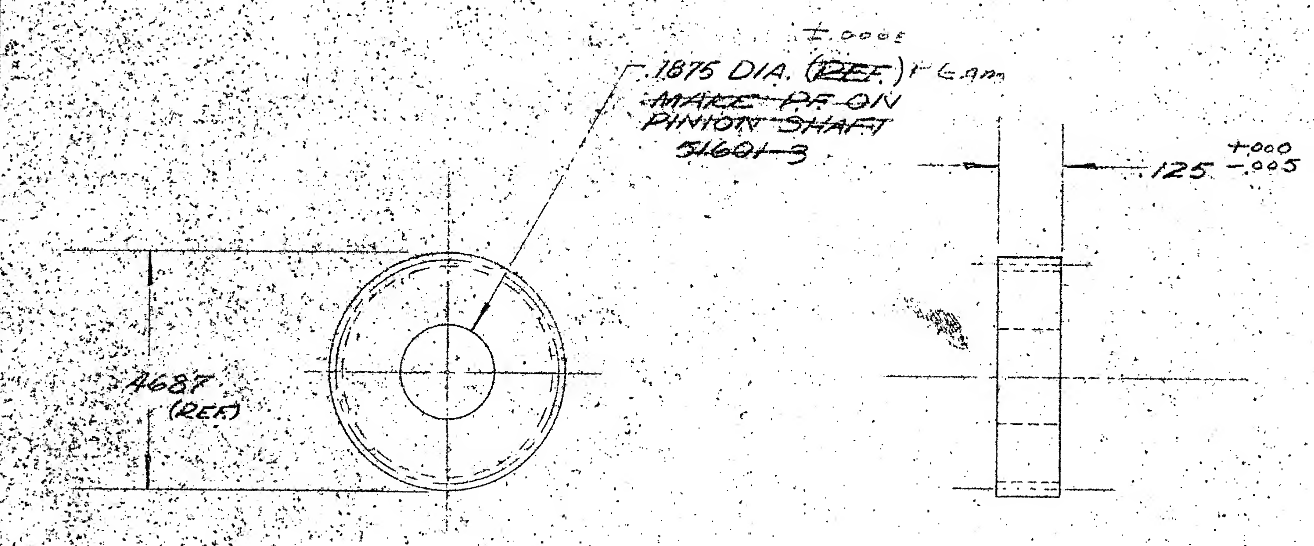
SCALE 4:1

STAT

TITLE SLIP RING

MAT. COINED SILVER

DWG NO 5160/028



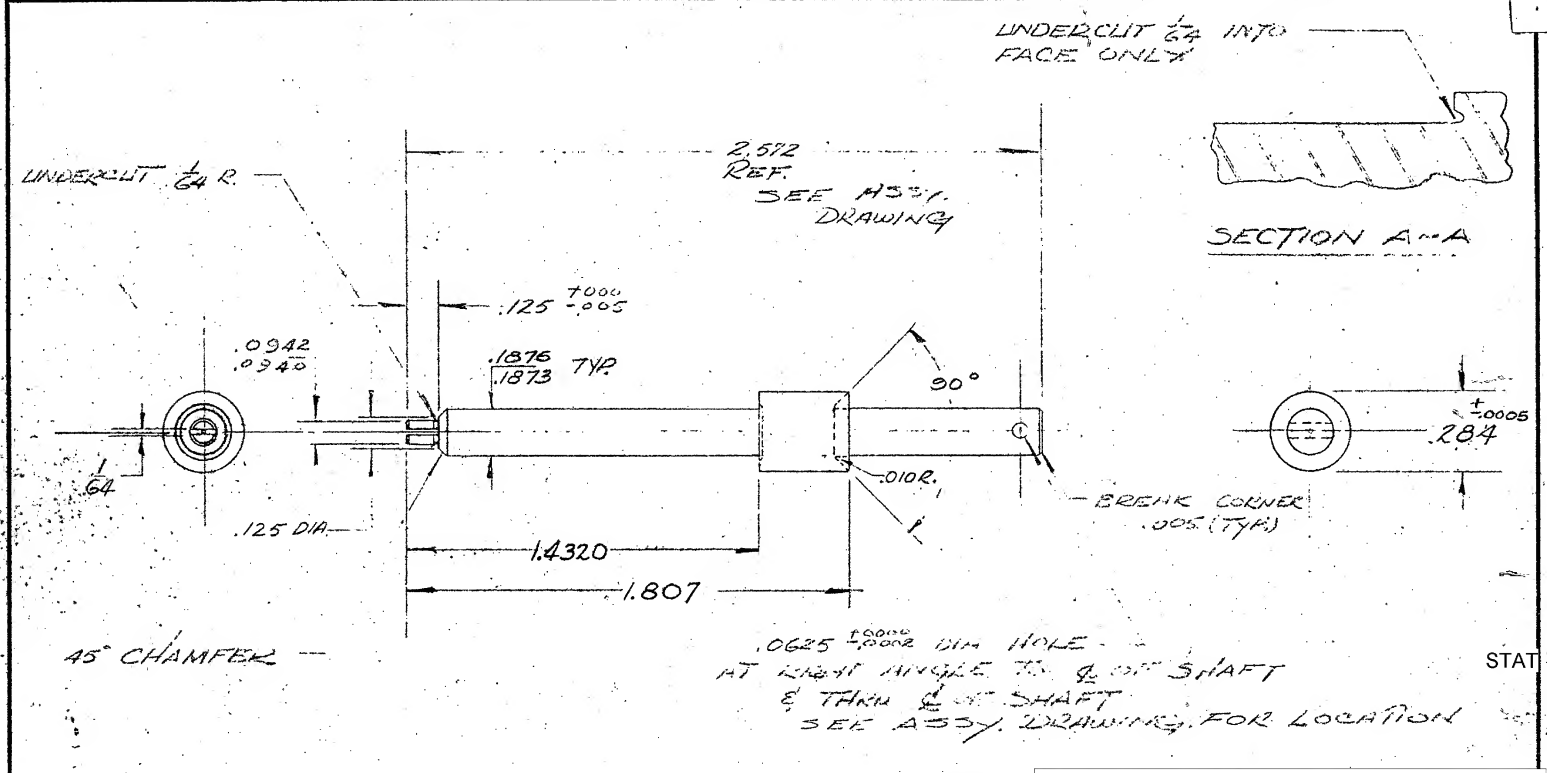
STAT

DIAMETRAL PITCH - 96
PITCH DIAMETER .4479
NO. OF TEETH 43
20° PRESSURE ANGLE

TOLERANCES, UNLESS OTHERWISE SPECIFIED, DECIMALS ± .005 FRACTIONS ± 1/64

MATERIAL NYLON G.S.	HEAT TREATMENT	SCALE 4:1	DATE 11/18/54	TITLE GEAR	EXP.
PATTERN NO.	ROCKWELL HARDNESS ___ TO ___ ON THE ___ SCALE	DRAWN BY J.E.	CHECKED BY		
CORE BOX NO.	FINISH	APPR. BY	TRACED BY		No. 51601-2

Eugene Dietzgen Co., Inc., New York, N.Y., No. 167A Ralton Tracing Paper



STAT

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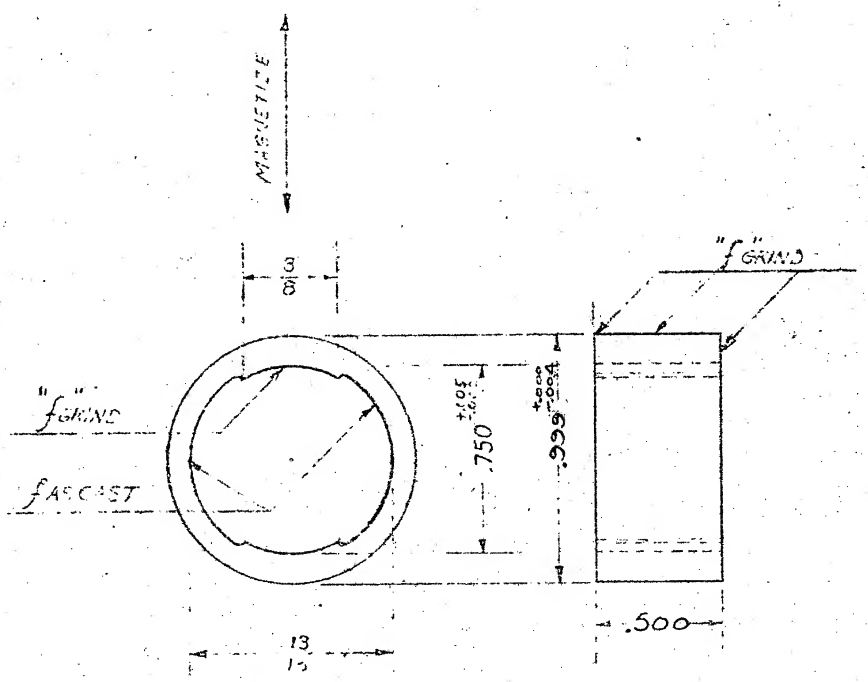
TOLERANCES, UNLESS OTHERWISE SPECIFIED,	DECIMALS ±.002	FRACTIONS ± 1/64	ANGULAR ±1/2°

MATERIAL	HEAT TREATMENT	SCALE	DATE	TITLE	EXP.
STAINLESS 303		2:1	12-17-54	REMATLRE SHAFT	
PATTERN NO.	ROCKWELL HARDNESS ___ TO ___ ON THE ___ SCALE	DRAWN BY	CHECKED BY		
CORE BOX NO.	FINISH	APPR. BY	TRACED BY		No. 51609-10

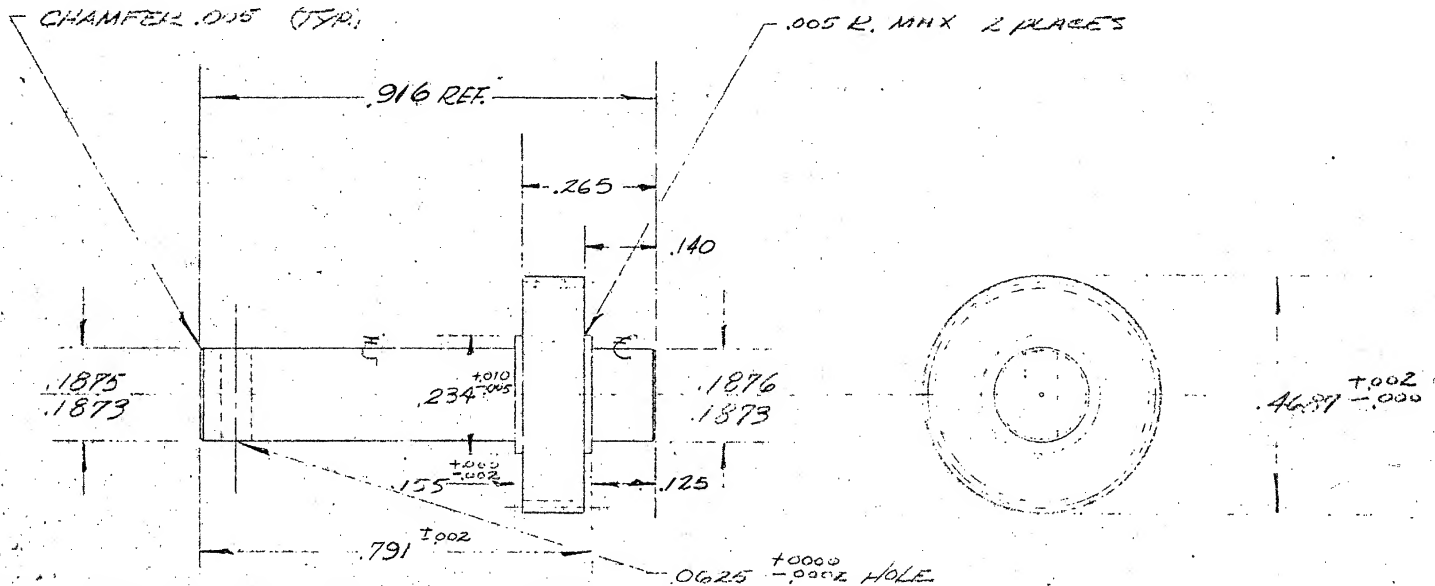


STAT

TOLERANCES, UNLESS OTHERWISE SPECIFIED, DECIMALS ±.002 FRACTIONS ± 1/32

MATERIAL: ALNICO 5	HEAT TREATMENT: IN FIELD AS SHOWN	SCALE: 1"	DATE: 9-10-57	TITLE: FIELD MAGNET	EXP.
PATTERN NO.	ROCKWELL HARDNESS, ___TO___ON THE___SCALE	DRAWN BY: WE	CHECKED BY		
CORE BOX NO.	FINISH: 75 % CLEANUP GRIND "f"	APPR. BY	TRACED BY		No. 5/601-020

Eugene Dietzgen Co., Inc., New York, N. Y. No. 167A Kalcon Tracing Paper



STAT

DIAS. MARKED ℄ TO BE CONCENTRIC WITHIN .0002 T.I.R.

DIAMETRAL PITCH - 96

PITCH DIA. .4479

NO. OF TEETH - 43

20° PRESSURE ANGLE

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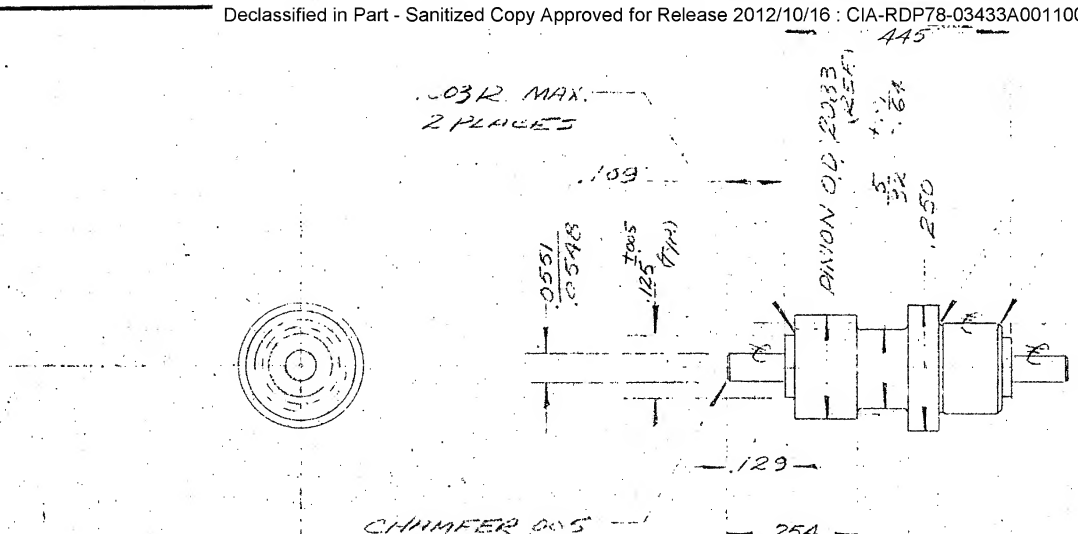
TOLERANCES, UNLESS OTHERWISE SPECIFIED, DECIMALS ± .003 FRACTIONS ± 1/64

MATERIAL: STAINLESS STL. 303	HEAT TREATMENT	SCALE: 4:1	DATE: 11/19/54	TITLE: GEAR	EXP.
PATTERN NO.	ROCKWELL HARDNESS ___ TO ___ ON THE ___ SCALE	DRAWN BY: JE.	CHECKED BY		
CORE BOX NO.	FINISH	APPR. BY	TRACED BY		No. 57601-4

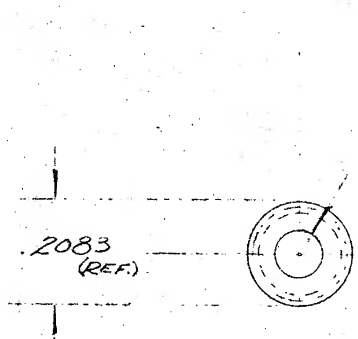


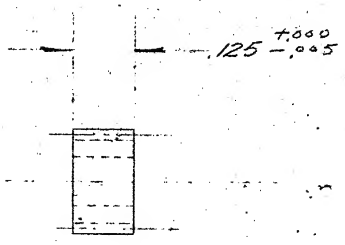
DIAS. MARKED ℄ TO BE CONCENTRIC WITHIN .002 T.I.R.
DIAMETRAL PITCH - 32
PITCH DIA. .1875
NO OF TEETH - 18
20° PRESSURE ANGLE

STAT.

TOLERANCES, UNLESS OTHERWISE SPECIFIED, DECIMALS ± .005 FRACTIONS ± 1/64

MATERIAL: STAINLESS STEEL 303	HEAT TREATMENT	SCALE: 4:1	DATE: 11/18/54	TITLE: PINION	EXP.
PATTERN NO.	ROCKWELL HARDNESS, ___TO___ ON THE___SCALE	DRAWN BY: JE	CHECKED BY		
CORE BOX NO.	FINISH	APPR. BY	TRACED BY		No. 51601-3





DIAMETRAL PITCH - 96
PITCH DIAMETER - .1875
NO. OF TEETH 18
20° PRESSURE ANGLE

STAT

TOLERANCES, UNLESS OTHERWISE SPECIFIED, DECIMALS ± .005 FRACTIONS ± 1/64

MATERIAL: STAINLESS STZ. 303	HEAT TREATMENT	SCALE: 4:1	DATE: 11/18/54	TITLE: PINION	EXP.
PATTERN NO.	ROCKWELL HARDNESS: ___ TO ___ ON THE ___ SCALE	DRAWN BY: J.E.	CHECKED BY		
CORE BOX NO.	FINISH	APPR. BY	TRACED BY		No. 51601-1

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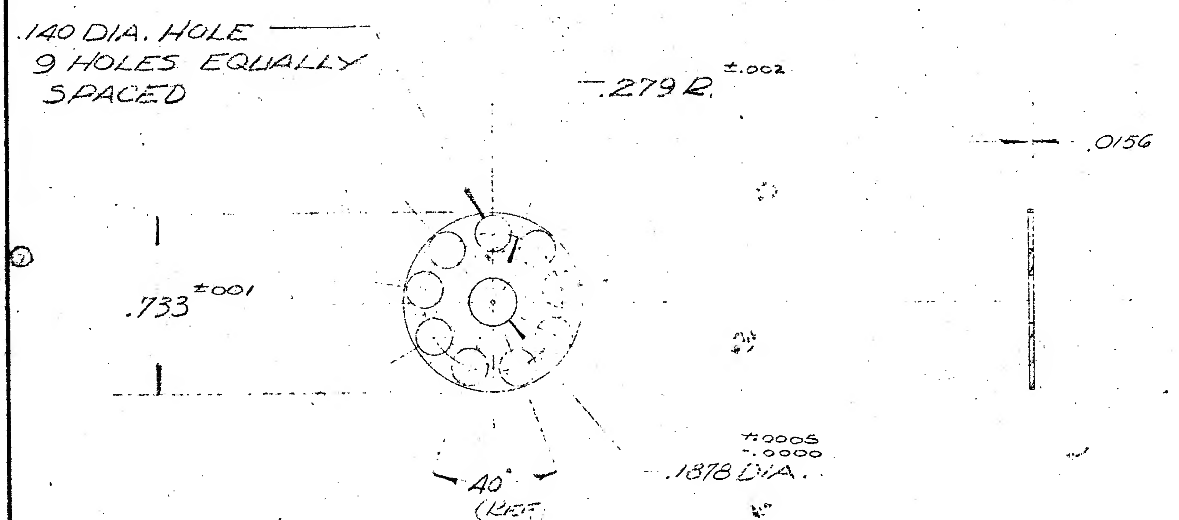

STAT

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TOLERANCES, UNLESS OTHERWISE SPECIFIED, DECIMALS ±.005 FRACTIONS ± 1/64 ANGULAR ± 1/2°

MATERIAL	HEAT TREATMENT	SCALE	DATE	TITLE	EXP.
PER MOLY		2:1	12-2-54	LAMINATION	
PATTERN NO.	ROCKWELL HARDNESS___TO___ON THE___SCALE	DRAWN BY: J.E.	CHECKED BY: [illegible] 12/21-1955		
CORE BOX NO.	FINISH	APPR. BY	TRACED BY		No. 5/6 01-012

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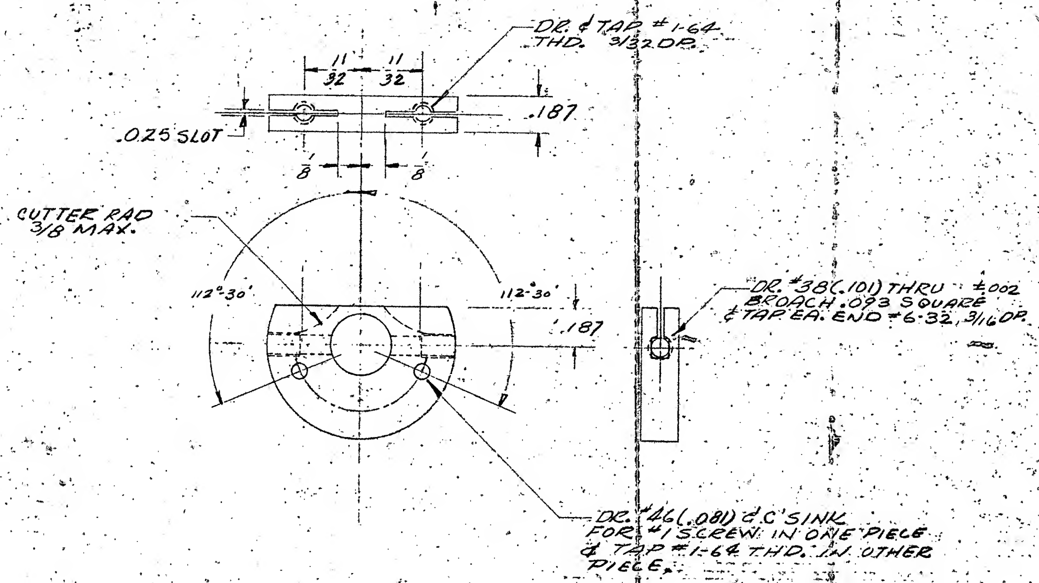
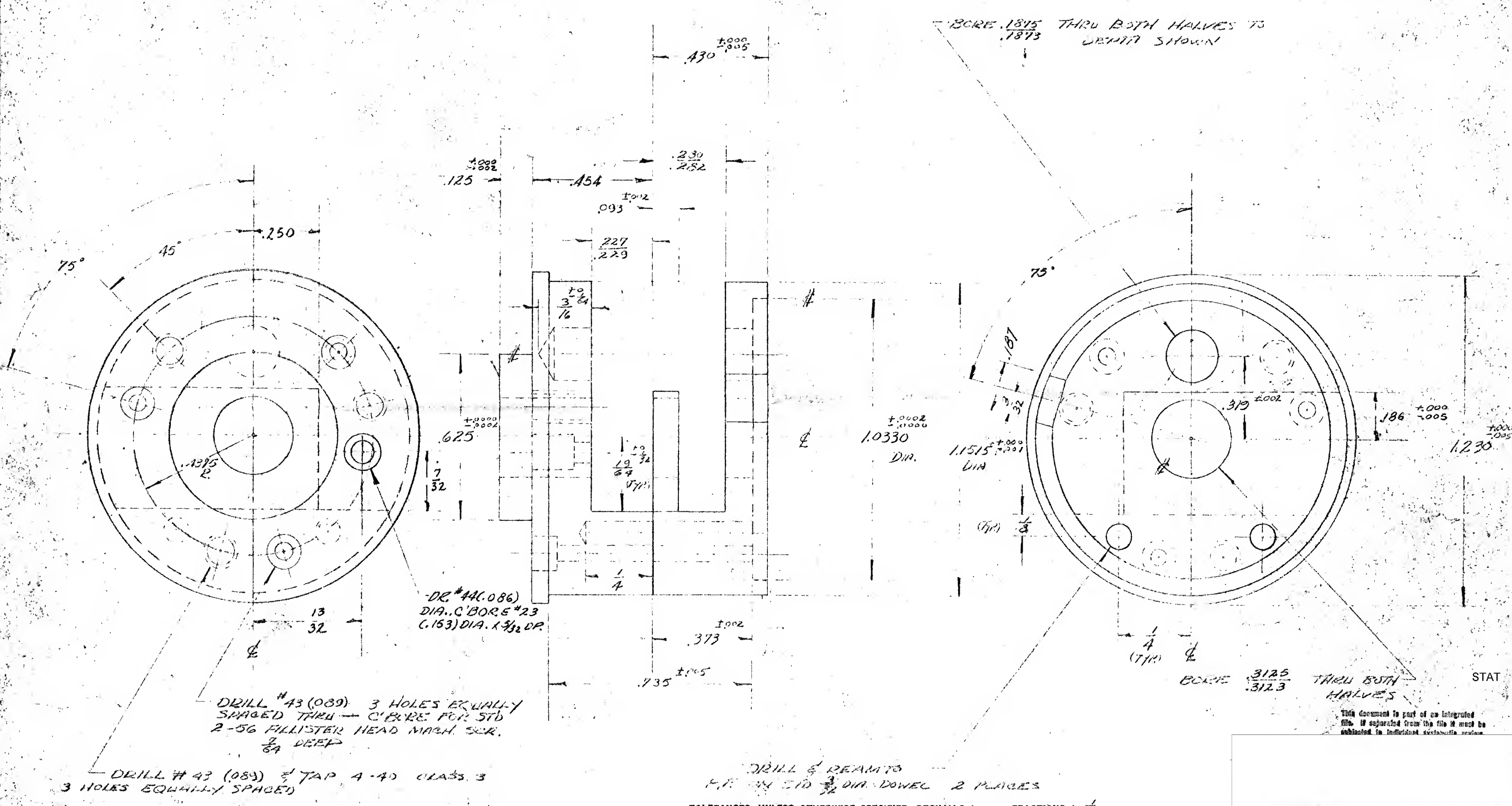


STAT

NOTE:
2 REQ'D PER UNIT
ONE WITH TAP
ONE WITH C'SINK

TOLERANCE
DEC. ±.005 FRAC. ± 1/64
BY DJL DATE 7-21-65
SCALE 2:1
TITLE BRUSH HOLDER
MAT. G.S. NYLON
DWG NO. 5164-011



STAT

TOLERANCES, UNLESS OTHERWISE SPECIFIED, DECIMALS ± .005 FRACTIONS ± 1/64

1. DIAMETERS MARKED ... TO BE CONCENTRIC WITHIN ... T.I.R.
2. HOLES TO BE BORED ... AND REAMED AFTER DOWLING ASSEMBLED.

MATERIAL: ALUMINUM 11 ST	HEAT TREATMENT	SCALE: 4:1	DATE: 12-15-54	TITLE: GEAR BOX
PATTERN NO.	ROCKWELL HARDNESS.....TO.....ON THE.....SCALE	DRAWN BY: J.E.	CHECKED BY: M/4785	
CORE BOX NO.	FINISH: ANODIZE	APPR. BY	TRACED BY	No. 51601-6